

# Work Order ID 71569

Wednesday, July 06, 2011 1:19:45 PM



Page 1

Item ID: D2803-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 7/6/2011

Start Qty: 6.00



Cust Item ID:

Required Date: 7/20/2011

Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: CL

Date: 11/07/06

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2803

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per File d2803-2

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B11-8-2

6561 5410

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA102

OK F.R. 11/08/03

6

(770)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK F.R. 11/08/03

6

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2603-2 PAR #: N/A Fault Category: Small Fob/water jet machine NCR: Yes No DQA: AS Date: 10-08-2011  
11-763 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/08/11

NCR: <u>71569</u>		WORK ORDER NON-CONFORMANCE (NCR) # <u>110</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/08/02</u>	<u>110</u>	<u>1 part scrap, the belt patern cut at wrong place, miss matl. around the Ø.75 hole <del>R.C. operator error</del> <u>training</u></u>	<u>AS</u> <u>02/12</u>	<u>destroy and replace Qty 1 Batch B <u>118271</u></u>	<u>and</u> <u>11/08/02</u>	<u>S</u> <u>11/08/03</u>	<u>AS</u> <u>02/12</u>	<u>S</u> <u>11/08/07</u>

NOTE: Date & initial all entries

**Work Order ID 71569**

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Item ID: D2803-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 7/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		B.A 11/08/03		6	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				6	0		11/08/05
145  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							6/1/06 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71569

Wednesday, July 06, 2011 1:19:45 PM



Page 3

Item ID: D2803-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 7/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>148</u>	0.00							
	Packaging	Memo							
Packaging		0.00							
160	QC21 - Final Inspection - Work Order Release	0.00							
	QC	Memo							
Quality Control		0.00							

148/15 (6)

CK 4/08/08

11-085 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Wednesday, July 06, 2011 1:19:42 PM

Work Order ID: 71569



Parent Item: D2803-2



Parent Item Name: Bracket

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 00.11.06 New Issue EC  
 IPP Rev:B Blanks now cut on Waterjet 06-06-14 JLM  
 IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC IPP  
 Rev:D add qc3 DD 10.02.19 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased	No			100	f	3.0000	1.9167	12.10547			



B11-8-2

6061-T6 Bar .500 x 10.00

Location	Loc Qty	Loc Code
MAT004	3	
111382	3	

118721

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

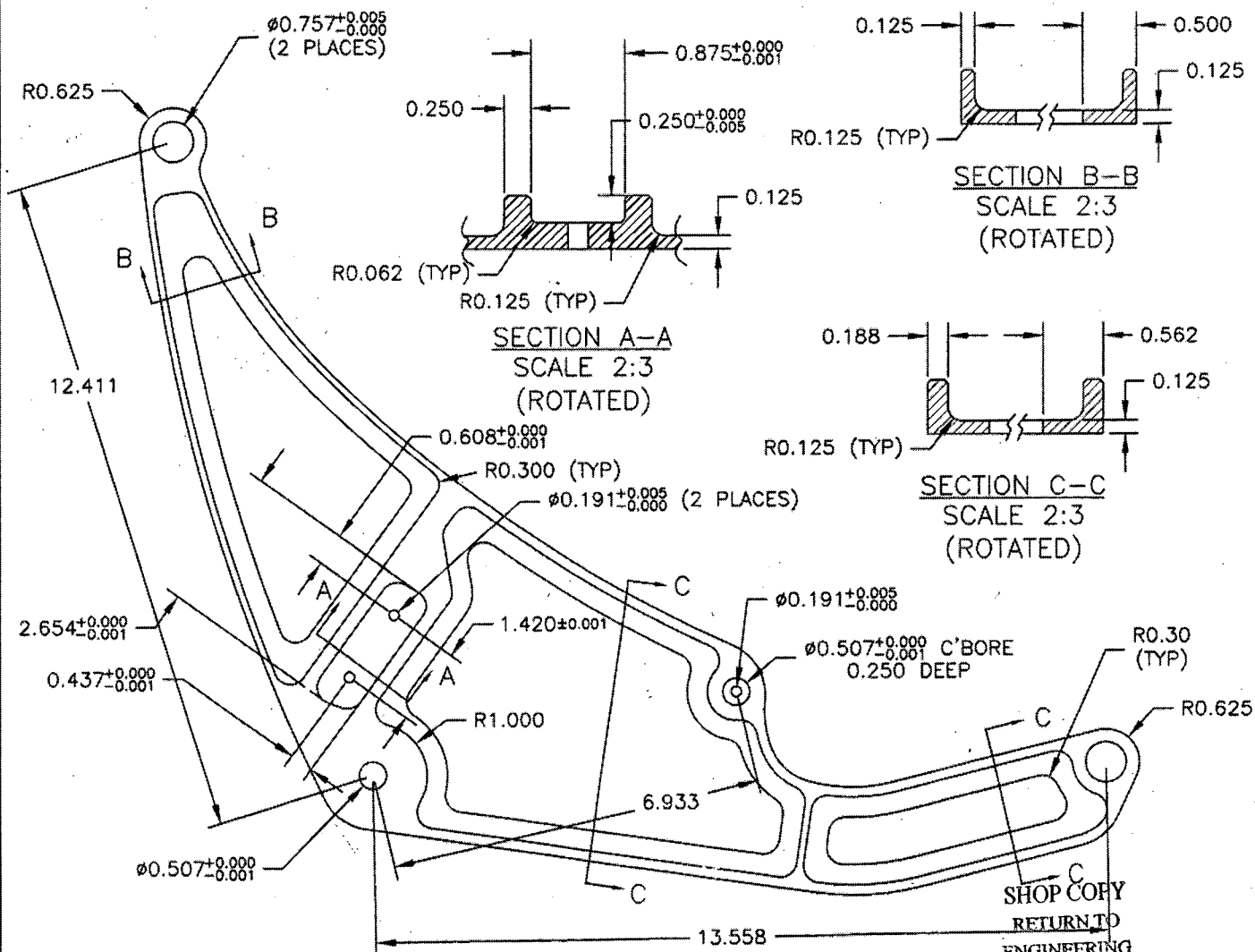


**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2803	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05-03-11



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71569

C24107106

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

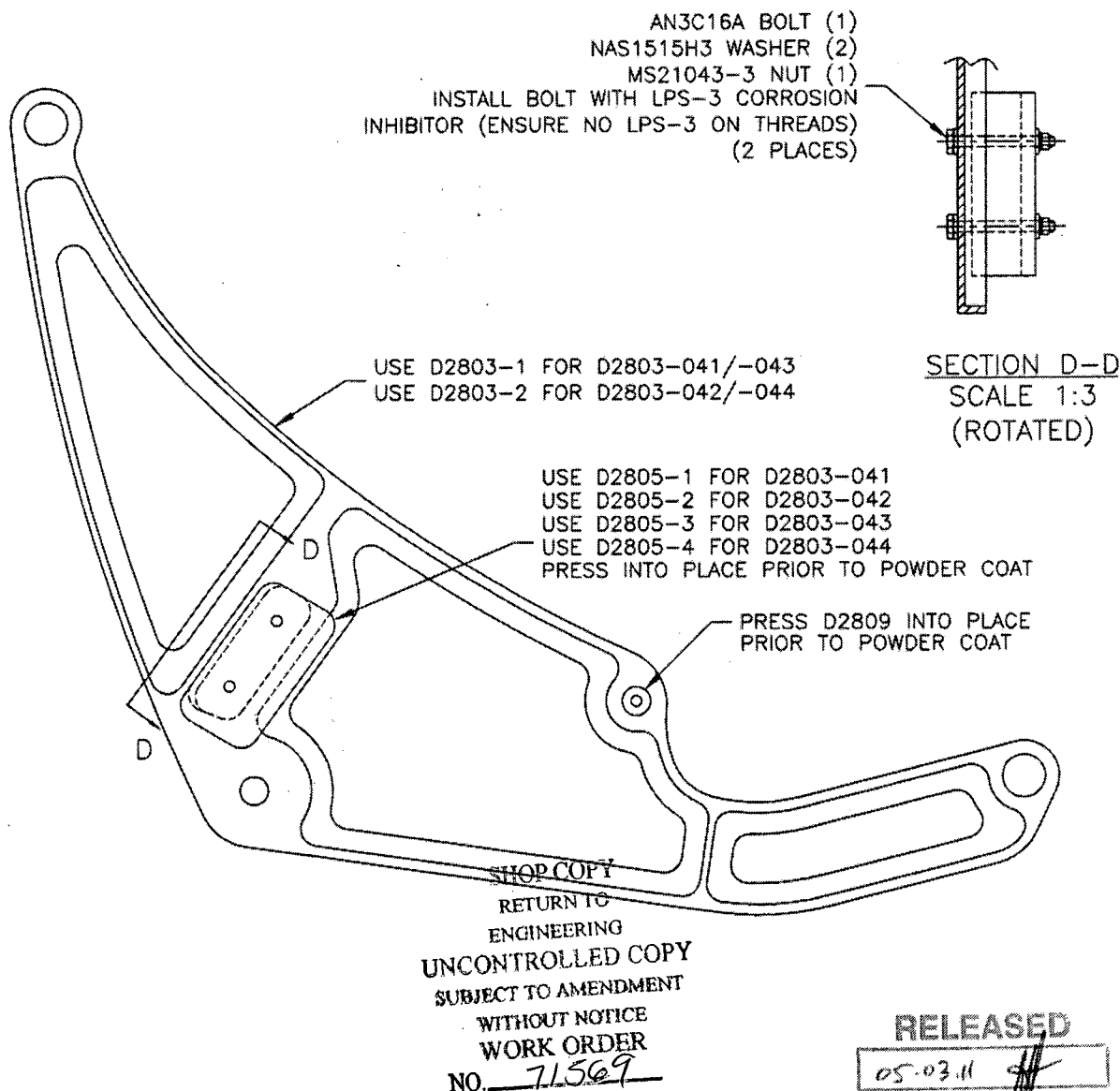
- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. B
				D2803	SHEET 2 OF 2
DATE				TITLE	SCALE
04.11.22				STA 84 BRACKET	1:3



**D2803-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	71569
<b>Description:</b> Bracket		<b>Part Number:</b>	D2803-2
<b>Inspection Dwg:</b> D2803	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.760	✓		Vern ML7	
1.420	+/-0.001	1.419	✓		"	
Ø0.191	+0.005/-0.000	.192	✓		"	
Ø0.507	+0.000/-0.001	.5065	✓		Mic ML8	
Ø0.507 x 0.250	+0.000/-0.001	.5063 x .250	✓		"	
12.411	+/-0.010	12.441	✓		Tape ML9	
6.933	+/-0.010	6.936	✓		Vern CNK2	
0.250	+/-0.010	.250	✓		Vern ML7	
0.875	+0.000/-0.001	.8744	✓		Mic ML8	
0.250	+0.000/-0.005	.249	✓		Vern ML7	
0.125	+/-0.010	.123	✓		"	
0.125	+/-0.010	.123	✓		"	
0.500	+/-0.010	.500	✓		"	
0.125	+/-0.010	.123	✓		"	
0.188	+/-0.010	.190	✓		Vern ML7	
0.562	+/-0.010	.562	✓		"	
0.125	+/-0.010	.125	✓		"	

<b>Measured by:</b> <i>ML/F.K.</i>	<b>Audited by:</b> <i>M.A.</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11/08/02	<b>Date:</b> 11/08/03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	
C	08.01.16	Tolerance revised for 0.875 dimension	KJ/EC/DD	